

Date: Friday, 07/12/2007 7:42:48 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	36172		
Estimate Number :	10436		
P.O. Number :		Part Number :	D33155
This Issue :	07/12/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3315 REV. B
First Issue :	//	Project Number :	N/A
Previous Run :	25727	Drawing Revision :	B
Written By :	<u>W</u>	Material :	
Checked & Approved By :		Due Date :	24/12/2007
Comment :	Est: A 05.05.12 New issue KJ/JLM Est Rev: B As per Rev B 06-03-24 JLM Est Rev: C Now on Waterjet 07-07-11 JLM		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 1.9262 sf(s)/Unit Total: 11.5574 sf(s)
 1010/1025/A21/6aA SHEET .060" THK

(BATCH: 105706) HB 07-12-10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

HB 07-12-10

(6)

2-Deburr if necessary

HB 07-12-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-12-10

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/12/08 (X6) counts

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1- Form using DT8751 Die as per Dwg D3315 Rev: B

2- Form using DT8179 Die as per Dwg D3315 Rev: B

SB

08/01/11

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 7:42:48 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36172

Part Number: D33155

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/01/11 46

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: 3

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M107553

08-1-05 6

8.0

QC10 + S

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/05

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

M 08/08/11

30 min

09/06/2008

S.296
#3367
#2
#3
#4 D33155

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/06/09 6

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-5, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 495

8/6/9

SD

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



08/06/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

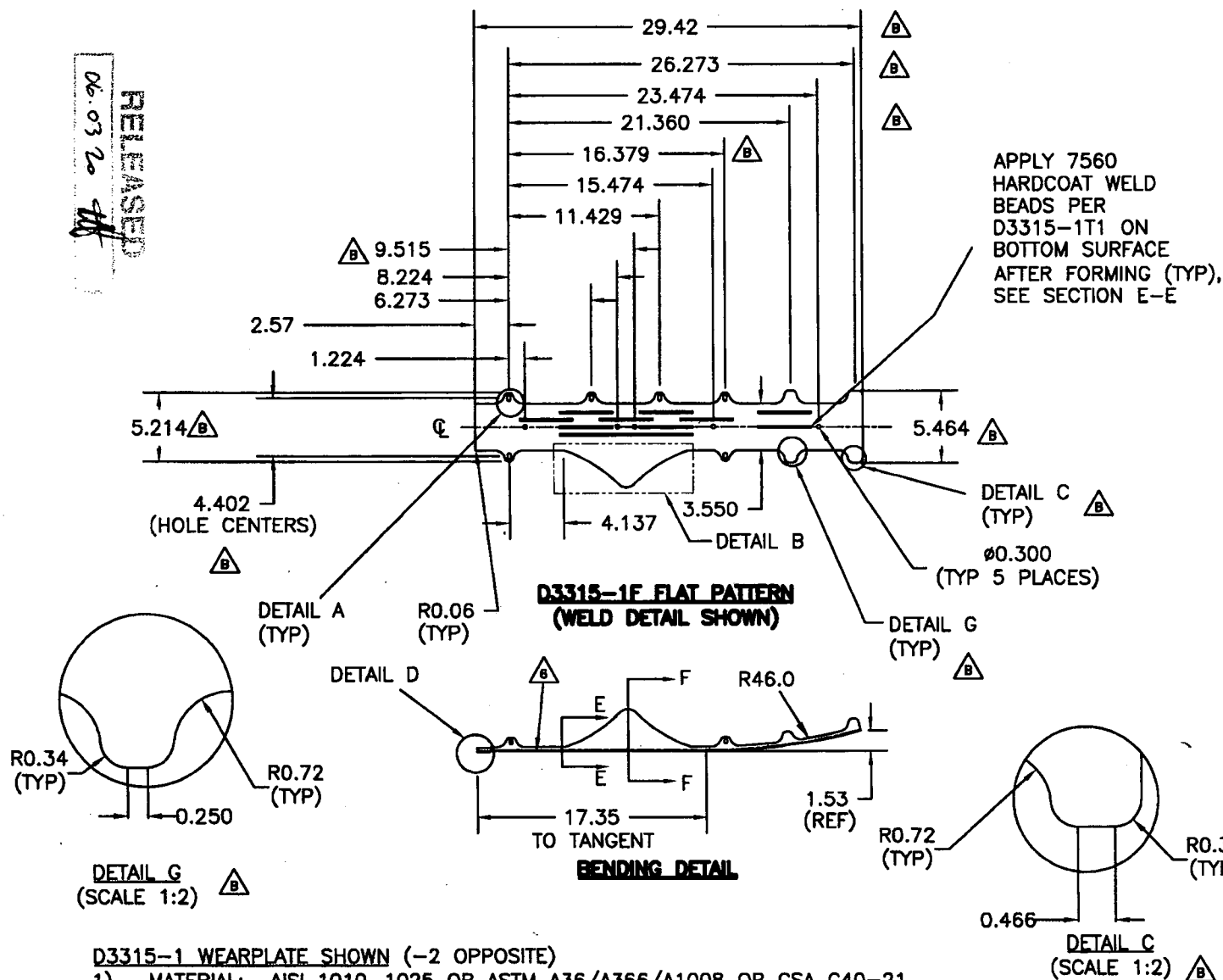
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
04	04		
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3315	SHEET 1 OF 4
DATE	TITLE	SCALE	
06.01.31	WEARPLATE	1:12	
A	04.09.10	NEW ISSUE	
B	06.01.31	UPDATE DIMENSIONS	

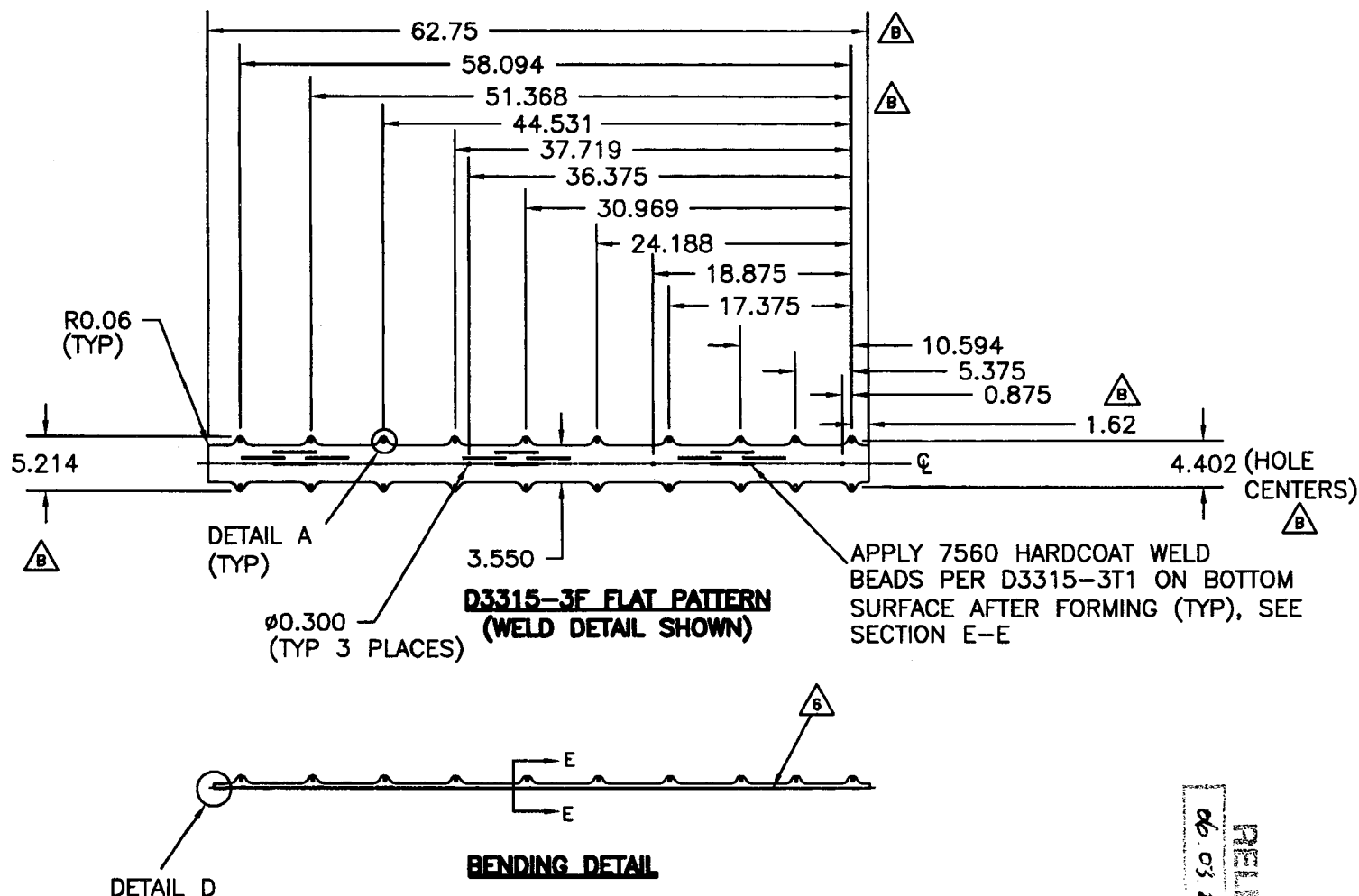


D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. B
DATE	06.01.31	TITLE	D3315	SHEET 2 OF 4
		WEARPLATE		SCALE 1:16

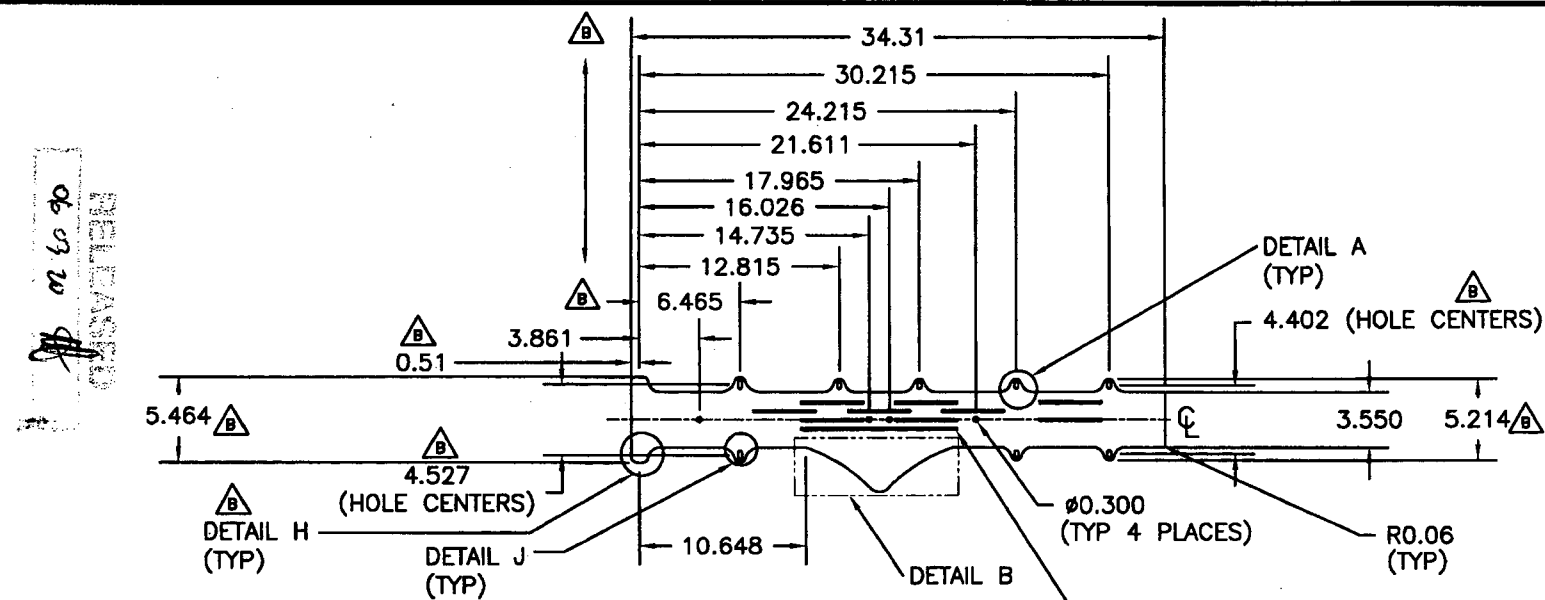


D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

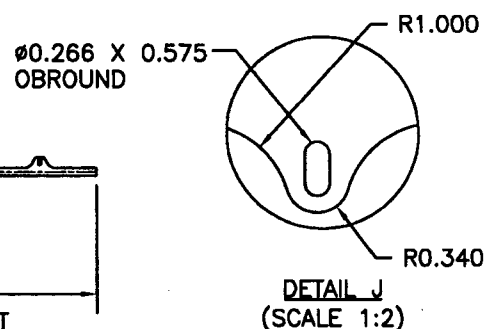
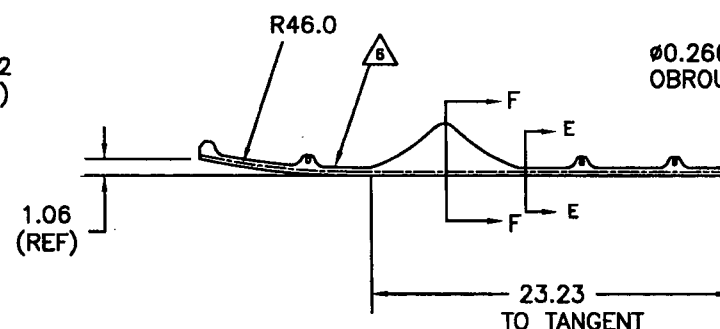
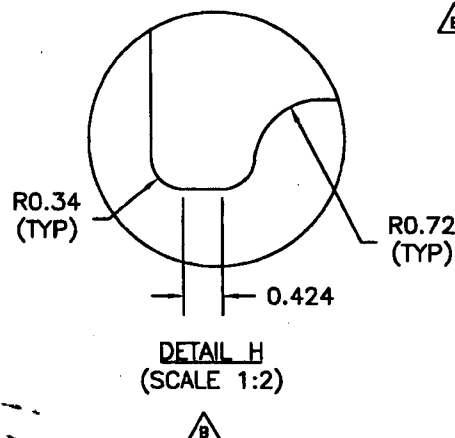
DART

DESIGN	DH	DRAWN BY	DH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 3 OF 4
				SCALE 1:12



**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

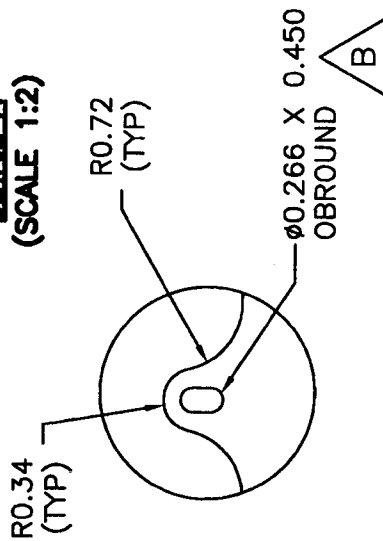
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RELEASED
06 03 20

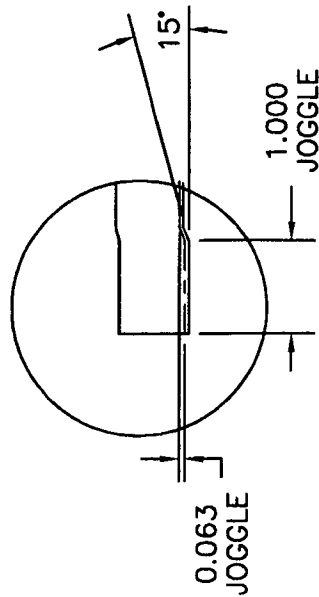
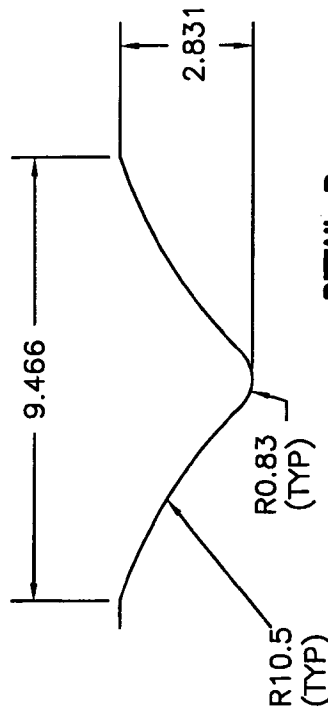
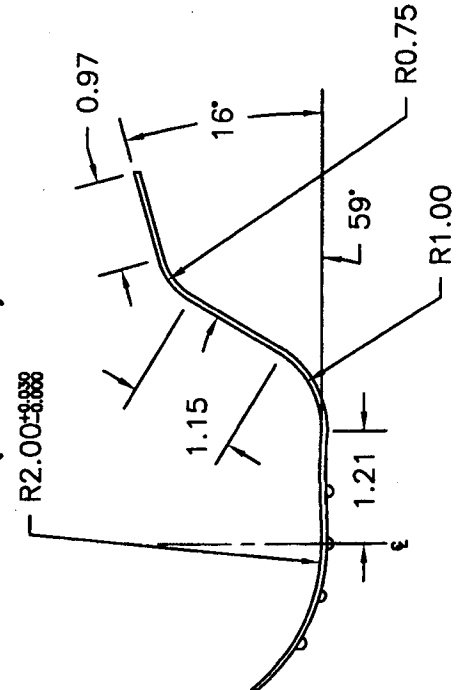
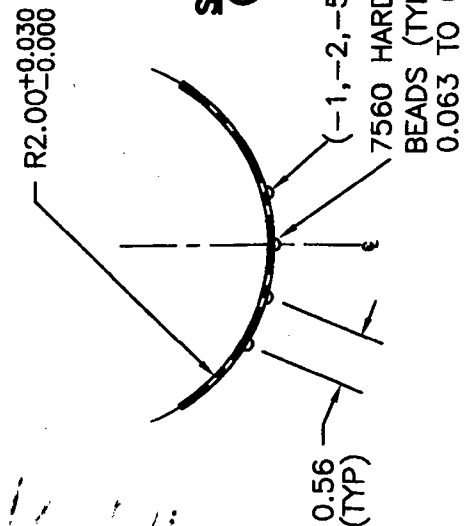
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

DETAIL A
(SCALE 1:2)

RELEASED

06.03.20

[Signature]**DETAIL D**
(SCALE 1:2)**DETAIL B**
(SCALE 1:4)**SECTION F-F**
(SCALE 1:2)**SECTION E-E**
(SCALE 1:2)

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DART AEROSPACE LTD		Work Order:	36172
Description: WEAR PLATE		Part Number:	D33IS-5
Inspection Dwg: D33IS-5 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .300	+ .006 - .001	.302	X			
.266	+/- .010	.268	X			
.450	+/- .010	.451	X			
.266	+/- .010	.268	X			
.575	+/- .010	.575	X			
3.550	+/- .010	3.554	X			
5.214	+/- .010	5.208	X			
5.464	+/- .010	5.464	X			
4.527	+/- .010	4.524	X			
4.402	+/- .010	4.400	X			
3.861	+/- .010	3.861	X			
6.465	+/- .010	6.465				
12.815	+/- .010	12.815				
14.735	+/- .010	14.735				
16.026	+/- .010	16.026				
17.965	+/- .010	17.965				
21.611	+/- .010	21.611				
24.215	+/- .010	24.215				
30.215	+/- .010	30.215				
34.31	+/- .030	34.31				

Measured by: RB	Audited by: J	Prototype Approval: R/A
Date: 07-12-16	Date: 07/12/16	Date: 12/16

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

